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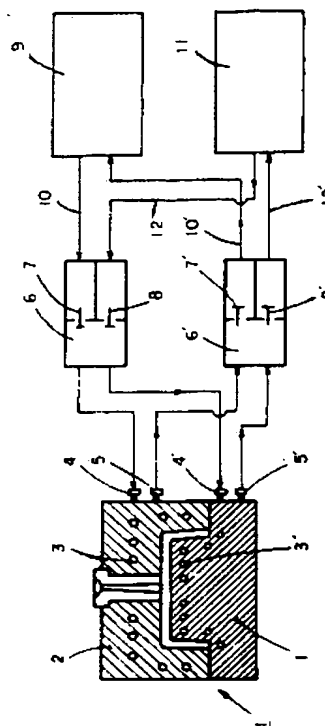
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TITLE : MANUFACTURE OF
ELECTROMAGNETIC
WAVE-SHIELDING SYNTHETIC RESIN
INJECTION MOLDING



ABSTRACT : PURPOSE: To avoid the exposure of conductive fillers to the surface of a molding by a method in which molds of a material having a higher heat conductivity than steel are heated to a temperature 30°C higher than the usual mold temperature, and a conductive filler-mixed synthetic resin is injected into the molds and the molds are quickly cooled.

CONSTITUTION: Prior to the injection of conductive filler-mixed synthetic resin for molding, the whole of molds 1 is heated to temperature 30°C higher than the usual mold temperature, preferably to a temperature range of 70~150°C, by directing hot water or steam obtained in a temperature regulator 9 into temperature-regulating holes 3 and 3' through a conduit 10, a three-way switch valve 6, and temperature-regulating inlets 4 and 4'. The hot water or steam reaches temperature-regulating outlets 5 and 5' and returns to the temperature regulator 9 through the three-way switch valve 6' and the conduit 10'. At the same time molding is made, the three-way switch valves 6 and 6' are switched to each other, and the mold core 1 and the mold cavity 2 are cooled by the cooling water of a refrigerator 11 to solidify the synthetic resin by cooling.

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